

Page 1

MAY 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 144727

Friday, April 22, 2016 3:25:12 PM

144727

Page 2

Item ID: D145-762-153 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Run-on Landing Wearplates for Standard Skidtubes, Fit LH or RH
Start Date: 5/9/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/12/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D145-762-153								
	Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

SAS
27
9-53

MAY 18 2016

16/5/25 9/10

mf
16-5-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐	Past Due ☐				

Picklist Print

Friday, April 22, 2016 3:25:19 PM

Page 1

Work Order ID: 144727

144727

Parent Item: D145-762-153

D145-762-153

Parent Item Name: Replacement Run-on Landing Wearplates for Standard Skid tubes, Fit LH or RH

Start Date: 5/9/2016

Required Date: 5/12/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.04.24 NEW ISSUE DD VERF:JLM IPP
REV:B 13.11.14 AS PER IIN REV.C DD VERF:JLM IPP REV:C
14.11.24 as per ecn14-654/chg003 DD VERF:JLM IPP REV:D 15.06.11 IIN
REV.D DD VERF:JLM IPP REV:E 16.02.05 IIN REV.E
(ecn16-514) DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4C43A		Purchased	No				Each	100.0000		4			
---------	--	-----------	----	--	--	--	------	----------	--	---	--	--	--

AN4C43A

BOLT

DAS
28
9-89

Location

Loc Qty

Loc Code

ST341

100

m132070

100

D4769-041

Manufactured No

110

Each

6.0000

1

1

D4769-041

Wearplate Assembly

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

6

133489

3

139036

3

D4773-041

Manufactured No

110

Each

0.0000

1

1

D4773-041

Wearplate Assembly

DAS
28
9-89

Manufactured No

110

Each

0.0000

1

1

D4771-041

Wearplate Assembly

DAS
28
9-89

**

**

**

**

MAY 05 2016

MAY 05 2016

144734

144733

DAS
6
27
9-89

DAS
6
27
9-89

DAS
6
27
9-89

DAS
6
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Picklist Print

Friday, April 22, 2016 3:25:19 PM

Page 2

Work Order ID: 144727

144727

Parent Item: D145-762-153

D145-762-153

Parent Item Name: Replacement Run-on Landing Wearplates for Standard Skid tubes, Fit LH or RH

Start Date: 5/9/2016

Required Date: 5/12/2016

Start Qty: 1.00

Required Qty: 1.00

D4764-1 Manufactured No 110 Each 74.0000 12 12

D4764-1

Bushing

DAS
6
27
9-89

Location Loc Qty Loc Code

ST124	74	
128558	4	
132495	70	

12

AN4C42A Purchased No 110 Each 38.0000 2 2

AN4C42A

Bolt

DAS
6
27
9-89

Location Loc Qty Loc Code

ST341	38	
M131947	38	

2

MS21043-4 Purchased No 110 Each 914.0000 6 6

MS21043-4

Nut

DAS
6
27
9-89

Location Loc Qty Loc Code

FG	40	
104603	40	
GA	103	
m132803	103	
OVER007	300	
m134502	300	
ST302	471	
m133769	171	
m134249	300	

6

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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		OTHER :																																																																		

144727

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Replacement Run-on Landing Wearplates for Standard Skid tubes, Fit LH or RH

Start Date: 5/9/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 5/12/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Jim [Signature] Date: 10/04/22 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

[illegible]

5.2 D145-762-013/-113 Skidtube Parts List

Item	Qty -013	Qty -043	Qty -053	Qty -113	Qty -153	Part Number	Description
	X					D145-762-013	SKIDTUBE WITH STD WEARPLATES
	1	X		1		D145-762-043	REPLACEMENT STD SKIDTUBE
	1		X			D145-762-053	REPLACEMENT WEARPLATES (STD SKIDTUBES)
				X		D145-762-113	SKIDTUBE WITH TRAINING WEARPLATES
				1	X	D145-762-153	REPLACEMENT TRAINING WEARPLATES (STD SKIDTUBE)
101		1				D4680-041	SKIDTUBE ASSEMBLY
102	2			2		**L321M1024101 OR **B321M1026101	SKID SHOE (REF ONLY)
103	8			8		**BRSP96/25-SK-WS-1 TEILIG OR **BRSP98/25-SK-WS-1 TEILIG OR **01618266098	CLAMP (REF ONLY)
104	8			8		**N/A	OEM BOLT (REF ONLY)
105	8			8		**N/A	OEM LOCKING WASHER (REF ONLY)
106	8			8		**N/A	OEM WASHER (REF ONLY)
110A		1				*D2965	CAP
110B		1				*D2965-3	CAP
111		4				***AELS-1032-225	INSERT
112		2				*AN3C5A	BOLT
113		2				*NAS1149C0332R	WASHER (OR AN960C10L)
114		2				*AN526C1032	SCREW
120A			1			D4682-041	WEARPLATE
120B			1			D4682-043	WEARPLATE
120C			1			D4682-7	WEARPLATE
121A				1		D4769-041	WEARPLATE
121B				1		D4773-041	WEARPLATE
121C				1		D4771-041	WEARPLATE
122			12		12	D4764-1	BUSHING
123			2		2	AN4C42A	BOLT
124			4		4	AN4C43A	BOLT
125			6		6	MS21043-4	NUT
130		3				*AELS-1032-130	INSERT
131		3				*AN3C4A	BOLT
132		3				*NAS1149C0332R	WASHER (AN960C10L)
150	2			2		AN6C52A	BOLT
151	2			2		D5300-1	GHL BUSHING
152	2			2		D5301-1	GHL PLUG
153	2			2		MS21043-6	NUT

* PART IS INCLUDED WITH D4680-041 STD SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE